

Date: Friday, 23/05/2008 9:53:10 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BELL CRANK
Job Number	: 39434	Part Number	: D2056
Estimate Number	: 11967	Drawing Number	: D2056 REV B2
P.O. Number	:	Project Number	: N/A
This Issue	: 23/05/2008	Drawing Revision	: B2
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 15/06/2008
Previous Run	: 37727	Qty:	30
Written By	:	Um:	Each
Checked & Approved By	: JULIE LECOCQ		
Comment	: Est. E 02.04.04 Added Rev.B2 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"	
		Comment: Qty.: 0.2494 f(s)/Unit Total : 7.4813 f(s) 6061-T6 Bar 1.25 x 1.25" Material: 6061-T6, 1.250" x 1.250"	Batch: M107744 <i>mk 08/06/21</i> (30)
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 2.80" long	<i>mk 08/06/21</i> (30)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2056 Tumble Deburr any rough edges after tumbling	<i>mk 08/06/21</i> (30)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>mk 08/06/21</i> (30)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>S 08/06/23 X 30</i> <i>counted</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1.		21/08/06/23 30X
7.0	POWDER COATING 	POWDER COATING m102316
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		7:35 320° 8:05 FL 08/06/24 SC
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 M-1 08/06/24 30X
10.0	QC21 	FINAL INSPECTION/W/O RELEASE ST 10 08 08/06/25 (X30)
Comment: FINAL INSPECTION/W/O RELEASE		08/06/25 (X30)
Job Completion		mf 08-06-25

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DART AEROSPACE LTD	Work Order:	39434
Description: Bell Crank	Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.750	✓			
0.900	+/-0.010	.900	✓			
1.000	+/-0.010	1.001	✓			
0.125	+/-0.010	.126	✓			
0.060	+/-0.010	.061	✓			
Ø0.191	+0.005/-0.001	.191	✓			
0.362	+/-0.010	.365	✓			
0.750	+/-0.010	.750	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	.260	✓			
0.100	+/-0.010	.100	✓			
0.300	+/-0.010	.300	✓			
0.946	+/-0.010	.946	✓			
0.750	+/-0.010	.750	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.637	✓			
0.375	+/-0.010	.375	✓			
Ø0.513-0.518	0.513 - 0.518	.518	✓			
R0.450	+/-0.010	.450	✓			
R0.125	+/-0.010	.125	✓			
R0.200	+/-0.010	.200	✓			
R0.550	+/-0.010	.550	✓			
R0.263	+/-0.010	.263	✓			

Measured by:	J.L.	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/06/20	Date:	08/06/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	DL

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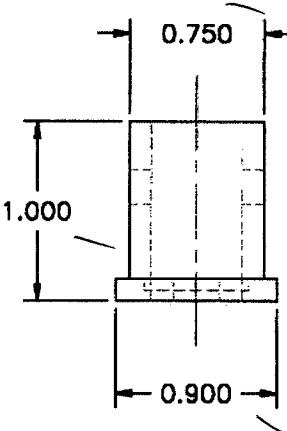
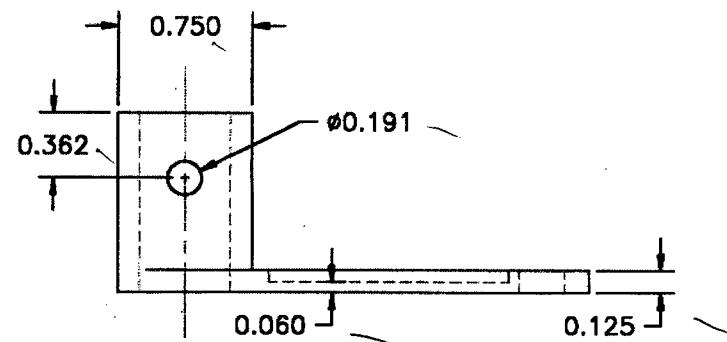
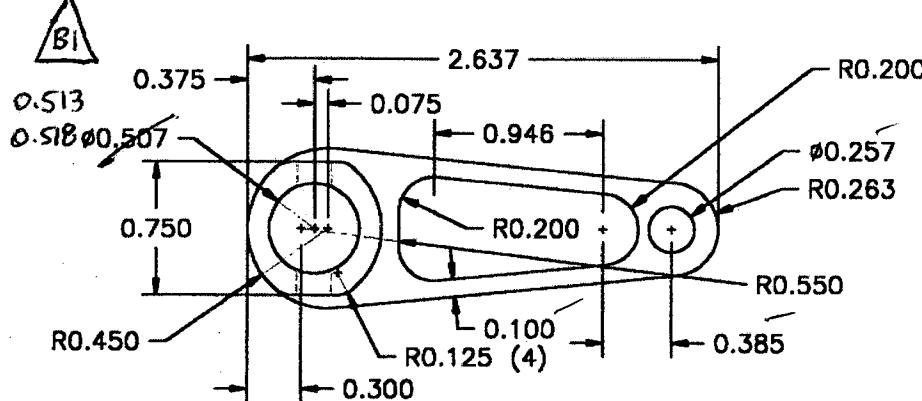
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DART

DESIGN		DRAWN BY	DART AEROSPACE LTD	
B	WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>BW</i>	<i>KE</i>	D2056	SHEET 1 OF 1	
DATE	92:03:13	TITLE	BELL CRANK	SCALE
B	95:11:02	RE-DESIGN		
B1	01.08.04	MODIFY HOLE SIZE / ADD PIC OPTIONAL		
B2	01.12.20	ADD NOTE ON TOLERANCES		



(B1) ACID ETCH & ALUDINE PER
DART QSI OOS 4.1
POWER COAT BLACK SHIMMER
(4.3.5.7) FOR DART
QSI OOS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART QSI OIS UNLESS OTHERWISE NOTED.

(B2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39434

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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